

Date: Tuesday, 10/02/2009 11:09:02 AM  
 User: Julie Dawson

## Process Sheet

|   |   |
|---|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services         | <b>Drawing Name</b> : BUSHING                               |
| <b>Job Number</b> : 45663                                     |   |
| <b>Estimate Number</b> : 10310                                |   |
| <b>P.O. Number</b> :  | <b>Part Number</b> : D26175                                 |
| <b>This Issue</b> : 10/02/2009 <b>S.O. No.</b> :              | <b>Drawing Number</b> : D2617 REV D2                        |
| <b>Prsht Rev.</b> : NC  | <b>Project Number</b> : N/A                                 |
| <b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS         | <b>Drawing Revision</b> : D2                                |
| <b>Previous Run</b> : 42937                                   | <b>Material</b> :   |
| <b>Written By</b> :   | <b>Due Date</b> : 19/02/2009 <b>Qty:</b> 20 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JP 09-2-10</u>          |   |
| <b>Comment</b> : Est H 04.07.14 Reformat; added step 5 KJ/JLM |   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |                  |                             |
|-----|------------------|-----------------------------|
| 1.0 | M6061T6T0500W058 | 6061-T6 RD Tube .500 x.058W |
|-----|------------------|-----------------------------|



**Comment:** Qty.: 0.0205 f(s)/Unit Total: 0.4095 f(s)  
 6061-T6 Round Bar 1.5"  
 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)  
 Ø0.500" tubing x 0.058" wall  
 M6061T6T0.500W.058)  
 Batch M110271

SA 09/02/14

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



**Comment:** HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617

2-Deburr

SA 09/02/14

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/02/14

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



**Comment:** SECOND CHECK

SA 09/02/17

|     |                 |                            |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 09-02-17

23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 11:09:03 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 45663

Part Number: D26175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

*JS*

09-02-17

*22*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:       

*P ST 39*

*JS 09/02/17 x22*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/02/19*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 09-02-18*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

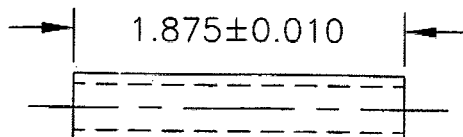
**NOTE:** Date & initial all entries



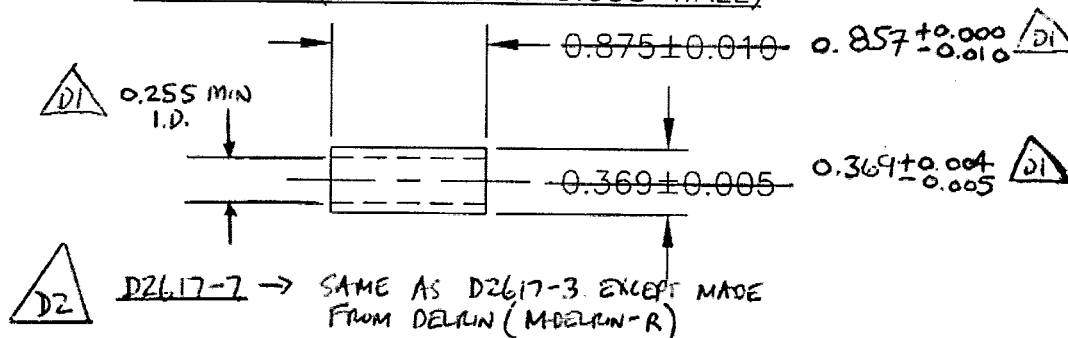


|         |          |          |    |   |                        |
|---------|----------|----------|----|---|------------------------|
| DESIGN  | BW       | DRAWN BY | CP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED | #        | APPROVED | #  | DRAWING NO.<br>D2617                              | REV. D<br>SHEET 1 OF 1 |
| DATE    | 01.07.04 |          |    | TITLE<br>BUSHING                                  | SCALE<br>1:1           |
| D2      | 04.09.10 | #        | CP | ADD D2617-7                                       |                        |
| A       | 96.10.08 |          |    | NEW ISSUE   |                        |
| B       | 97.05.08 |          |    | .875 WAS 1.125                                    |                        |
| C       | 97.06.04 |          |    | 0.369 DIA WAS 0.375                               |                        |
| D       | 01.07.04 |          |    | ADD MAT'L SPEC AND TOL./DIM. NOTE                 |                        |
| D1      | 04.07.12 | #        | CP | CORRECT TOLERANCE (NCR 779)                       |                        |

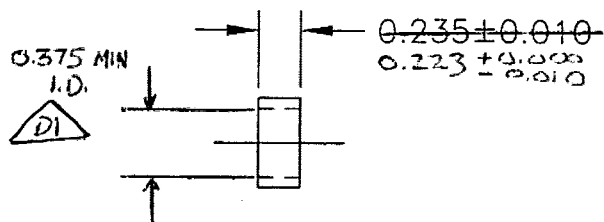
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED  
01.07.05 #

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. HS603

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.